

Work Order ID 65667

Wednesday, February 23, 2011 1:07:37 PM



Page 1

DUPLICATE

Item ID: D4271-013

Accept



Setup Start



Revision ID:

Item Name: Aft Beam Assembly

Stop



Start Date: 1/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *11-02-23* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4271

B

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Pick and Assemble as per dwg

2/11/02/24 @

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2/11/02/24

(H)

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

*PPR
66324*

2/11/02/24 @

Work Order ID 65667

Wednesday, February 23, 2011 1:07:37 PM



Page 2

Item ID: D4271-013

Accept



Setup Start



Revision ID:

Item Name: Aft Beam Assembly

Stop



Start Date: 1/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

11/02/24 
WF

11-02-24

Picklist Print

Wednesday, February 23, 2011 1:07:33 PM

Page 1

Work Order ID: 65667

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly



Start Date: 1/21/2011

Required Date: 1/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC
11.01.26 RevB dwg EC verified by:DD

IPP RevB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4148-3 Stud Receiver, Lower		Manufactured	No			100	Each	2.0000	1	1			
<div> <div>Location</div> <div>ST132</div> <div>63722</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4148-5 Eyebolt Stud		Manufactured	No			100	Each	5.0000	1	1			
<div> <div>Location</div> <div>GA</div> <div>66225</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4274-3 Plate, Aft Support		Manufactured	No			100	Each	4.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div>65886</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4276-1 Aft Beam		Manufactured	No			100	Each	1.0000	1	1			
<div> <div>Location</div> <div>WA</div> <div>65671</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

EP 11/02/24

EP 11/02/24

EP 11/02/24

EP 11/02/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 1:07:33 PM

Page 2

Work Order ID: 65667

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 1/21/2011

Required Date: 1/28/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C12A

Purchased

No

100

Each

96.0000

6

8



Bolts



EB 11/02/24

Location

Loc Qty

Loc Code

ST351

96

112314

8

114761

11

116022

2

116289

17

116786

8

116924

50

M116786 (C)

MS20615-4M18

Purchased

No

100

Each

190.0000

8

8



Rivet



EB 11/02/24

Location

Loc Qty

Loc Code

ST323

190

114808

128

115037

62

8

MS21043-3

Purchased

No

100

Each

1,270.000

6

8



Nut



EB 11/02/24

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1194

112314

1194

86

Wednesday, February 23, 2011 1:07:34 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 1:07:34 PM

Page 3

Work Order ID: 65667

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 1/21/2011

Required Date: 1/28/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

100

Each

2,804.000

12

16



Washer



EP 11/02/24

Location

Loc Qty

Loc Code

ST297

2804

115000

125

115698

35

116025

108

116304

2536

12

* MS21043-4 QTY: 2 BATCH: M116188 EP 11/02/24

* NAS1149C0432R QTY: 4 B#: M116900 EP 11/02/24

* AN4C13A QTY: 2 B#: M116914 EP 11/02/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

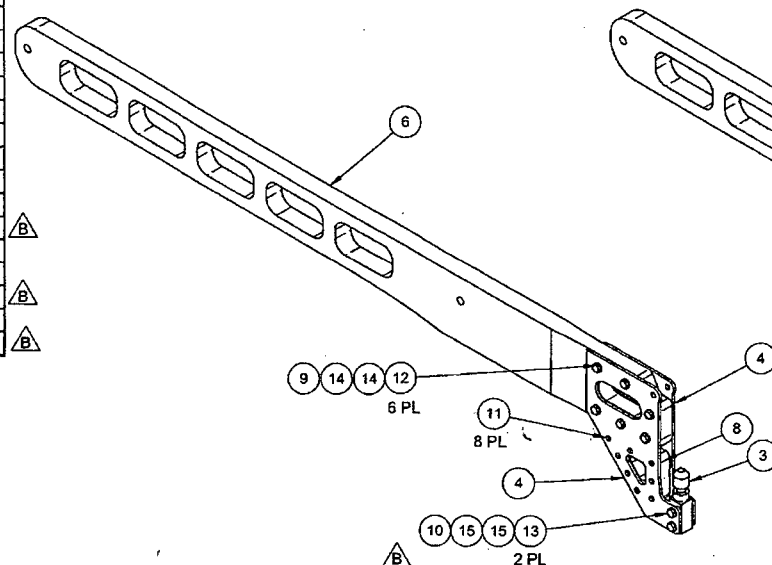
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

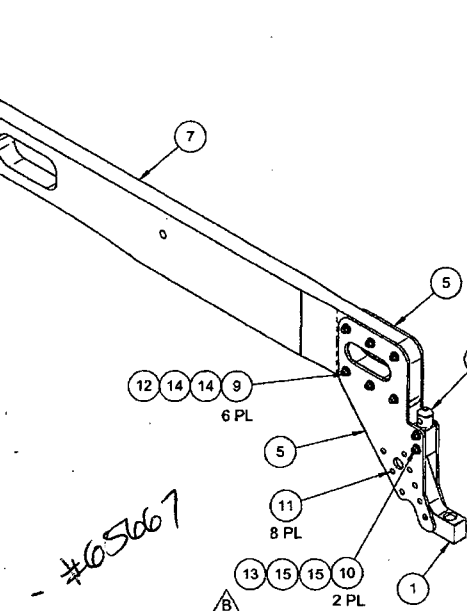
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1	1	1	D4148-3	STUD RECEIVER
2	1	1	D4148-5	EYEBOLT STUD
3	1		D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7	1		D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	6	6	AN3C12A	BOLT
10	2	2	AN4C13A	BOLT
11	8	8	MS20615-4M18	RIVET
12	6	6	MS21043-3	NUT
13	2	2	MS21043-4	NUT
14	12	12	NAS1149C0332R	WASHER
15	4	4	NAS1149C0432R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

RELEASED
R 2010-12-06

B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO.	REV. B
MFG. APPR.	#	D4271	SHEET 1 OF 2
APPROVED	#	TITLE	SCALE
DE APPR.	#	SUPPORT BEAM ASSEMBLIES NTS	
DATE	10.12.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

